

Work Order ID 64106

November 24, 2010 12:43:00 PM



Page 1

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 11/24/10 Start Qty: 20.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: CLDate: 10/11/24 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	B								

100



Bandsaw

Jeaspa Bandsaw

0.00

Memo

CUT BLANK 1.50" LONG

Cut C metec

0.00

N0



HAAS 1

HAAS CNC vertical machine #1

0.00

Memo

MACHINE AS PER FOLIO FA865 AND DWG
FOLIO REV: _____
DWG REV: _____CL 10/11/24 20

DEBURR

issue P/O. to metec P/O. 13000

Machine as per drawing D 3910 Rev. B

Purchasing

Work Order ID 64106

Page 2

November 24, 2010 12:43:00 PM

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 11/24/10 Start Qty: 20.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

120

QC NC'd

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

receive + inspect for transit damage.

Memo

0.00

11/24/29 (ac)

130



QC

Quality Control

QC6 Inspect parts - second check

0.00

Soculzo

Counted

X70

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

10/11/30

0.00

X20

0

Work Order ID 64106

Page 3

November 24, 2010 12:43:00 PM

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 11/24/10 Start Qty: 20.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

150



Powdercoat

M. 15951 START 2:00
 Memo OVEN T. 320°
 FINISH 2:50

20

BL 10-11-30.

0.00

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> M 10/11/30

20

A

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: 507

0.00

Memo

0.00

10/11/30 C 200

Work Order ID 64106

Page 4

November 24, 2010 12:43:00 PM

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 11/24/10 Start Qty: 20.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

QC21- Final Inspection - Work Order Release

0.00

10/12/01 JH

Quality Control

Memo

0.00

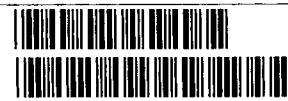
B10-12-1
(20)

Picklist Print

Page 1

November 24, 2010 12:42:59 PM

Work Order ID: 64106



Parent Item: D3910-1



Parent Item Name: Crosstube Lug

Start Date: 11/24/10

Required Date: 11/30/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 		Manufactured	No			100	f	291.6744	0.13	2.736842		C21011125	

Lug Extrusion

Location	Loc Qty	Loc Code
MAT06	291.6744265	
43722	180	
45800	111.674426	2.736842

D3910-1P

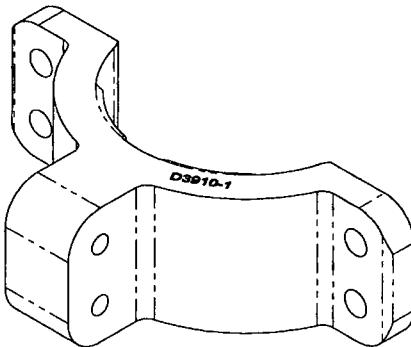
x20

8 7 6 5 4 3 2 1

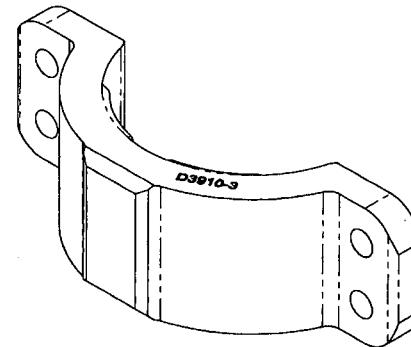
D
C
B
A
D
C
B
A

CD10111124

W10:6/104



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

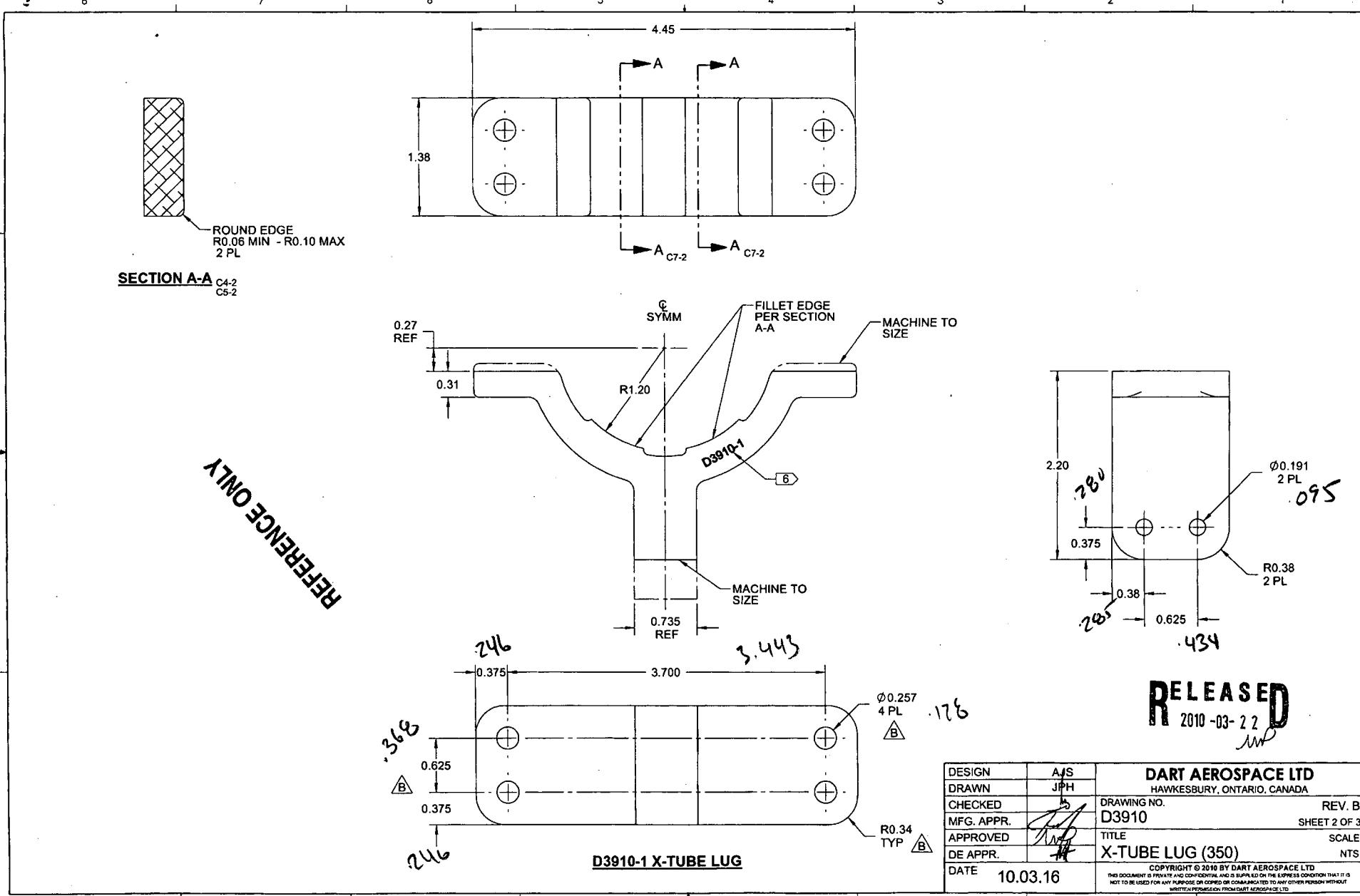
NOTES:

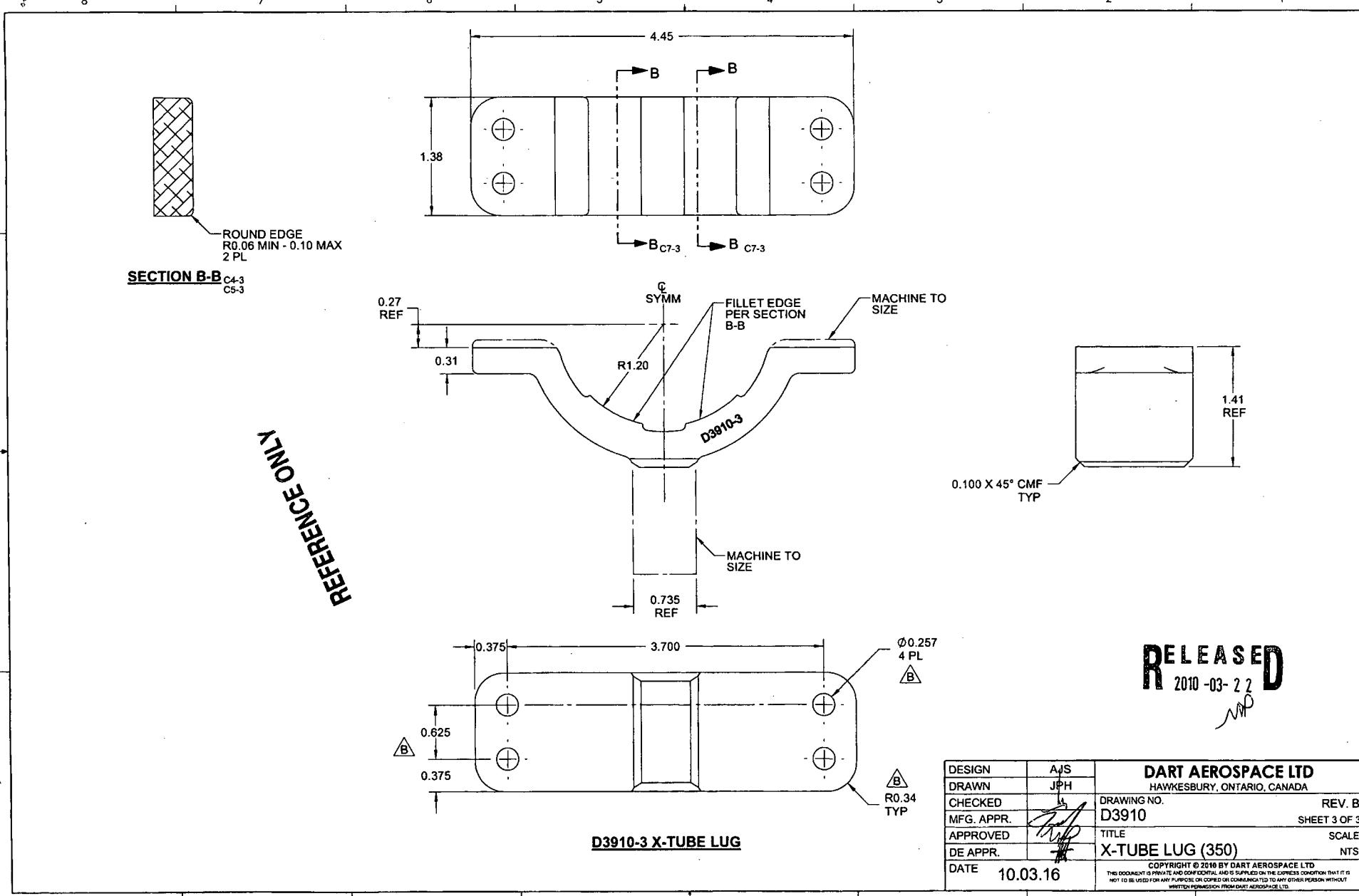
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

8 7 6 5 4 3 2 1

D
C
B
A
D
C
B
A

B	$\varnothing 0.257$ HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-807-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	







Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13000

Purchase Order Date 11/24/10

PO Print Date 11/24/10

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr.

Buyer	Chantal Lavoie
Requisition Nbr	
Tax Resale Nbr	10127-2607
Terms	Net 30
Currency	CAD
FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
FAXED
(2/10/11/20)

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

Change Nbr: 1

Change Date: 11/24/10



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	D3910-3	Crosstube Lug	13000
20	D3910-1	Crosstube Lug	13000

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink that appears to read "Shigi Walz".

Shigi Walz

Vankleek Hill, November 29, 2010